

Work Order ID 163018

Monday, July 03, 2017 9:13:17 AM

163018

Reprint

Page 1

Item ID: D2563 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Weldment Assembly
 Start Date: 6/27/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/30/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: ~~DAS~~ 21 Date: JUL 03 2017 Tooling: Date: Run Start *NR1*
 QC: ~~9-89~~ Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								

100 Weld per dwg A/R Aluminum rod Batch: 13658
 Large Fab

100

Large Fab

Large Fab

Memo

2.20

JUL 05 2017

DAS
24
9-89

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg
 D2563 using DT 8343

4- Grind

4x D.M.L. 1917-07-04
 4c CC 17-7-5

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

17-07-05
 DAS
9
9-89

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[illegible]

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Item ID: D2563

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Weldment Assembly

Start Date: 6/27/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/30/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: 137078 Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind	2.20				<i>cf</i>		JUL 06 2017	DAS 24 9-89
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<i>y</i>			DAS 38 9-89 JUL 06 2017
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<i>y</i>			DAS 38 9-89 JUL 06 2017

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 Required Date: 6/30/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	Pressure Wash per QSI005 4.3	0.00							
175	HandFinish	0.50				(X4)	Ø	201707107	BEB
Hand Finishing	Memo Touch up Alodine as per QSI005								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180	Powdercoat	0.44							4, Ø 17-07-10. 233
Powder Coating	Memo Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3								
	START TIME: 11:05 OVEN TEMPERATURE: 220 FINISH TIME: 11:35								
190	Wing Walk as per dwg QSI005 4.4 Batch M13F47	0.00							
190	HandFinish	1.53							4 x of 22 126216
Hand Finishing	Memo								

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Start Date: 6/27/2017 Start Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00							
200									DAS
QC	Memo	0.04				7			38
Quality Control									JUL 11 2017
210	Identify as per dwg & Stock Location: PK6	0.00							
210									
Packaging	Memo	0.04							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.40							
Quality Control									

4 SD 17/20/2017
17/1/24DAS
21
8-39

JUL 20 2017

Picklist Print

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Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 6/27/2017

Required Date: 6/30/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116		Manufactured	No			100	Each	47.5000	1	4			
D2244-116									**				
Step Extrusion													

D.M.L. 2017-07-04

Location	Loc Qty	Loc Code
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WA003	47.4999632	
150064	47.5	

D2561		Manufactured	No			100	Each	24.0000	2	8			
D2561									**				
Lug													

CC 17-7-4

Location	Loc Qty	Loc Code
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WA003	24	
159277	24	

D2564		Manufactured	No			100	Each	19.0000	2	8			
D2564									**				
Mounting Angle													

CC 17-7-4

Location	Loc Qty	Loc Code
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WA003	19	
159203	19	

D2673-34		Manufactured	No			100	Each	93.0000	1	4			
D2673-34									**				
End Plate													

CC 17-7-4

Location	Loc Qty	Loc Code
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WA003	93	
160473	93	

4x

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D2563

Parent Item Name: Step Weldment Assembly

Start Date: 6/27/2017

Required Date: 6/30/2017

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

150

Each

93.0000

1

4

D2673-34

End Plate

CC 17-7-4

Location

Loc Qty

Loc Code

WA003

93

160473

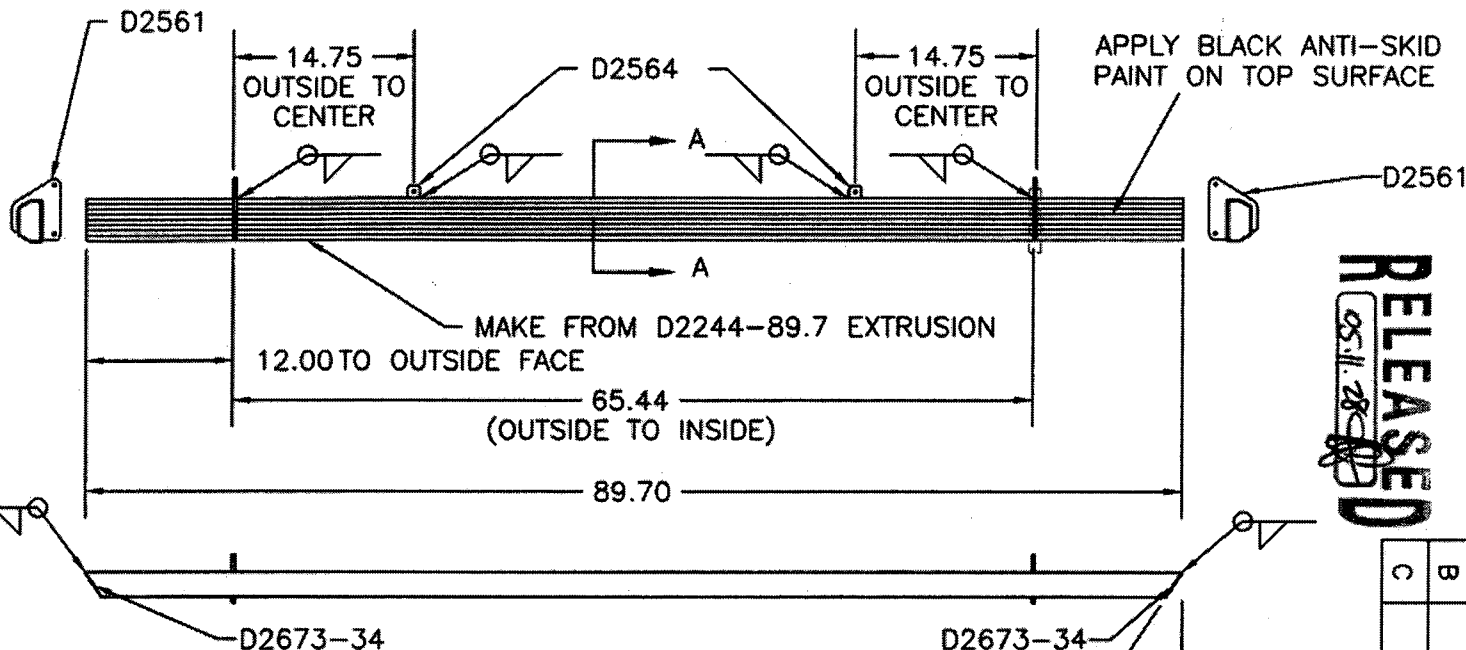
93

4X

DART

RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
BIW	<i>PH</i>	DRAWING NO.	REV. C
CHECKED <i>PH</i>	APPROVED <i>PH</i>	D2563	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.11.14	STEP WELDMENT ASSEMBLY	1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *163018* *MCS* *1707-03*

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED